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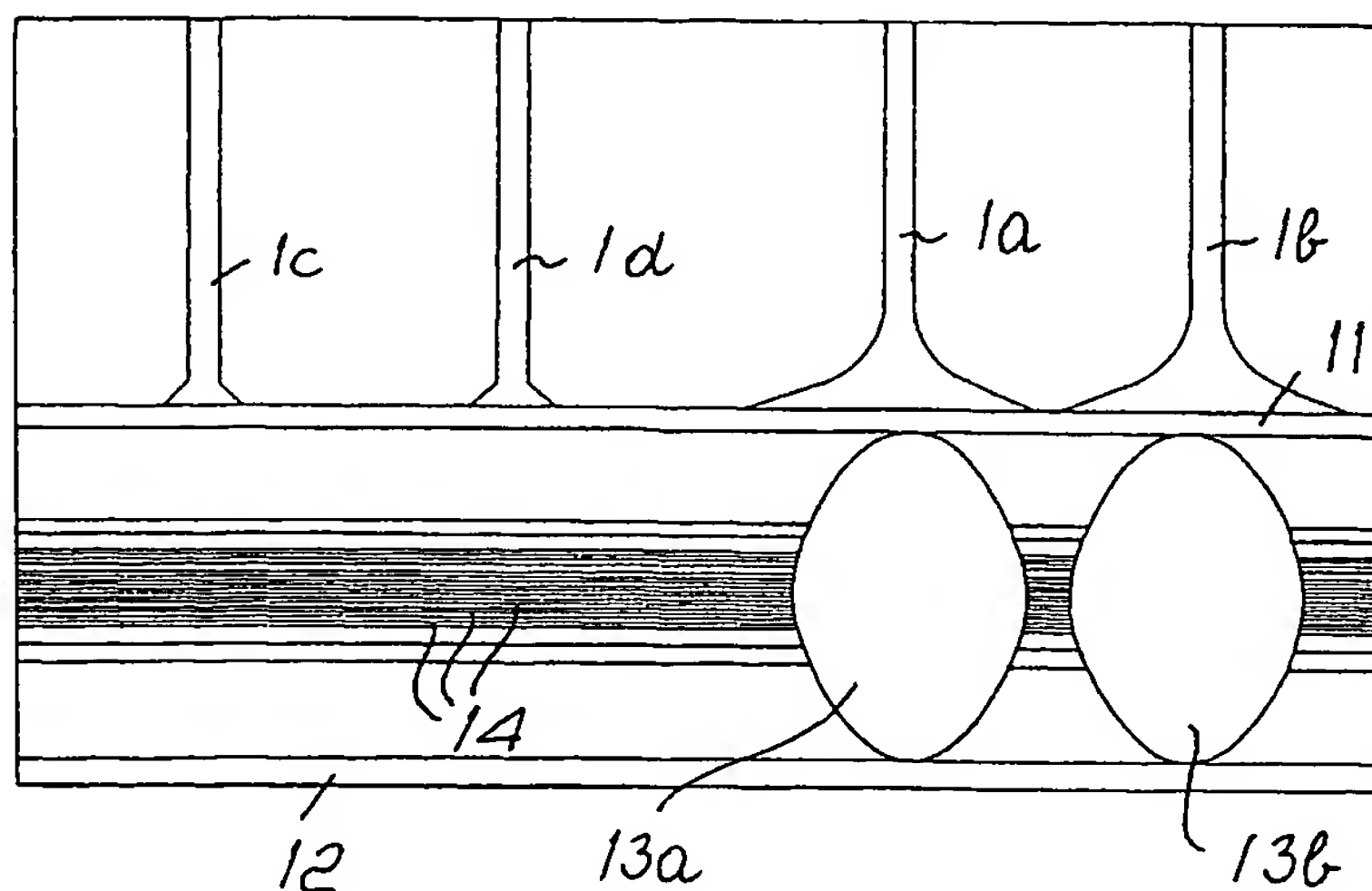
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[Continued on next page]

(54) Title: METHOD FOR MANUFACTURING KNITTED ARTICLES WITH A CIRCULAR KNITTING MACHINE FOR FORMING ITEMS OF CLOTHING WITHOUT LATERAL SEAMS



(57) Abstract: A method for manufacturing knitted articles for forming items of clothing, such as body suits, sleeveless tops, undershirts, bras, underpants or the like, without lateral seams, with a circular knitting machine, that comprises at least one step for forming tabs (1a, 1b, 1c, 1d, 2a, 2b, 2c, 2d, 3a, 3b), in which exclusively all or some of the needles that belong to at least one sector of the needle cylinder are moved so as to knit at at least one feed or drop of the machine, and the needle cylinder of the machine is actuated with an alternating rotary motion about its own axis, with an extent of oscillation that is sufficient to produce the transit, at the at least one cited feed, of all the needles of the at least one sector that are moved to knit at that feed, in order to make these needles form a preset number of rows of knitting.



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— *before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments*

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INTERNATIONAL SEARCH REPORT

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A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 D04B1/22 D04B9/20

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 7 D04B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

| Category * | Citation of document, with indication, where appropriate, of the relevant passages | Relevant to claim No. |
|------------|--|-----------------------|
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| X | GB 1 078 462 A (BONNETERIE S A ET) 9 August 1967 (1967-08-09) | 1-8 |
| Y | page 1, line 25 - line 58 page 2, line 29 - line 40; claim 1 page 4, line 16 - line 41; figures 11-14 page 4, line 95 - page 5, line 12; figures 15-17 | 1-8 |
| Y | US 4 038 699 A (BURN WILLIAM H) 2 August 1977 (1977-08-02) column 4, line 12 - line 65; figures | 9-12 |
| | -/- | |

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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- *Z* document member of the same patent family

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International Application No
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C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

| Category * | Citation of document, with indication, where appropriate, of the relevant passages | Relevant to claim No. |
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| X | GB 1 328 693 A (BENTLEY ENG CO LTD) 30 August 1973 (1973-08-30) page 4, line 37 - line 75; figure 10 ----- | 1-7 |
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| A | US 1 072 640 A (NYDEGGER M) 9 September 1913 (1913-09-09) the whole document ----- | 9-12 |

INTERNATIONAL SEARCH REPORT

International application No.
PCT/EP2004/006731

Box II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:
because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☒ As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
- ☒ No protest accompanied the payment of additional search fees.

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 1-8

Method for forming tabs on a circular knitting machine

1.1. claim: 13

Completion border

2. claims: 9-12

Method for forming pockets on a circular knitting machine

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/EP2004/006731

| Patent document cited in search report | | Publication date | Patent family member(s) | Publication date |
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